

Date: Thursday, 07/08/2008 12:58:53 PM
User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D412-742-013

Job Number : 41049

Estimate Number : 10804

P.O. Number :

Part Number : D412742013

This Issue : 07/08/2008 S.O. No. :

Drawing Number : DSI 9369/ECN08-510/RTN

Prsht Rev. : NC

Project Number :

First Issue : / / Type : LANDING GEAR

Drawing Revision :

Previous Run : 41046

Material :

Due Date : 14/08/2008 Qty: 1 Um: Each

Written By : Checked & Approved By : 

Comment :

Additional Product

DART

TRANSPORT CANADA APPROVAL # 09-09

TEL: 1-613-632-3336
FAX: 1-613-632-4443

PN	D412-742-013	CHG	CHG003
DESC	Float Skidtube	STC	SR01583SE
LOT	B37973	STC	SH05-37
MODEL	205/210/212/412/AB412	STC	

US PATENT # 5735484
CANADA FOREIGN PATENTS PENDING

MADE IN CANADA

Job Number:



Seq. #: Machine Or Operation: Description

1.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REMOVE FROM STK:

D412-742-013 B 37973

2.0 D412742013 Float Skidtube Installation



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Float Skidtube Instln

3.0 HAND FINISHING 1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

REMOVE END CAPS BOTH ENDS
TO REMOVE/CLEAN LPS FROM TUBE

FORWARD TUBE TO SKIDTUBE CELL

FL 08/08/08 (1) (PR)

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

A) - DRILL 0.500 DIAM. HOLES THRU D3391-021 FWD TUBE AND D3391-023 MID TUBE(2 PLACES) AS SHOWN ON DSI 9364.

INSTALL D3591-1 BUSHING B 31514

B) - DEBURR ALL HOLES

- TOUCH UP ALODINE

- TOUCH UP PAINT

C) - RECOAT WITH LPS3 B 106096

FL 08/08/08 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/6/11	#40	After tube was pulled out of DAMAGED box's it was found that a large scratch in powder coat above AFT END of the mid tube above the last stop SADDLE hole.	KS/11/11	Suffl with 320 grit SAND paper	FD 08/06/11	S 08/06/11	KS/11/11	S 8/6/11
		touch up scratch if needed per QSI 005		FD 08/06/11				
		R.C. Damaged During returny	KS/11/11	Apply Powder coat with set heat gun. Per QSI 005	FD 08/08/11	S 08/08/11	KS/11/11	S 8/8/11

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

D35911

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
BUSHING

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REINSPECT KIT FOR 100% COMPLETENESS

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE PER PPP USING NEW B/N.
NEW PAPERWORK & LABELS REQ'D
CHG 005
-ENSURE DSI PAPERWORK ADDED

JLD 08.8.13

RUE

AS

8/08/19

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

Job Completion



MF 08-08-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN PH	DRAWN BY AJS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. DSI 9364	REV. C SHEET 1 OF 1
DATE 08.08.06	TITLE BUSHING INSTALLATION		SCALE NTS
A	07.01.16	NEW ISSUE	
B	07.03.20	ADD TOLERANCE TO 1/2" HOLE	
C	08.08.06	ADDED CHG 005 & SUBS TO EFFECTIVITY. TOLERANCE ON 1/2" HOLES WAS +0.006 -0.000	

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-742 REV. B AND ICA-D412-742 REV. 1

REF. FAA STC: SR01583SE

REF. CANADIAN STC: SH05-37 ISSUE 1

TO PREVENT THE D3391-011/-021 FWD TUBE FROM MOVING WITH RESPECT TO THE D3391-013/-023 MID TUBE, CUSTOMERS RECEIVING D412-742-011/-013 SKIDTUBES AT CHG 002 OR CHG 005 AND SUBSEQUENTS HAVE A D3591-1 BUSHING INSTALLED AT THE FWD SADDLE HOLES AS SHOWN IN DETAIL A (2 PLACES).

CUSTOMERS WITH D412-742-011/-013 SKIDTUBES AT CHG 001, CHG 003 AND CHG 004 CAN PROCURE THE DSI 9364-011 KIT AND INSTALL THE D3591-1 BUSHINGS AS FOLLOWS:

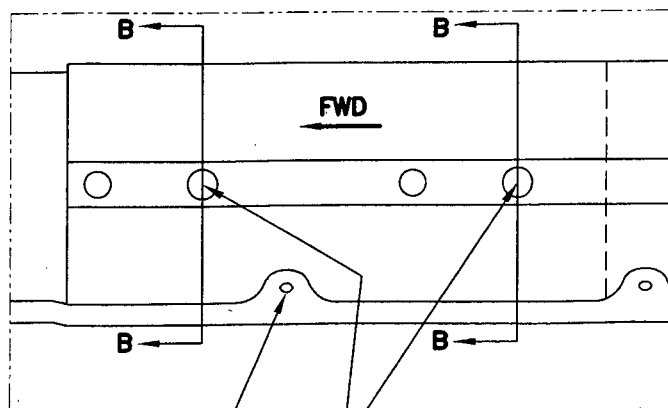
- 1) REMOVE SKIDTUBE/SADDLES FROM AIRCRAFT USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE.
- 2) TRANSFER DRILL 1/2" HOLES ($\varnothing 0.500 \pm_{0.000}^{0.002}$) INTO THE FWD SADDLE HOLES AT THE LOCATIONS SHOWN (2 PLACES) THRU THE D3391-013/-023 MID TUBE AND D3391-011/-021 FWD TUBE. **DO NOT OPEN UP HOLES IN D2571/D2572 FWD SADDLES.**
- 3) REMOVE FWD TUBE FROM MID TUBE, DEBURR DRILLED HOLES, TOUCH UP HOLES WITH MIL-P-85582 OR MIL-P-23377 PRIMER
- 4) RE-INSTALL D3391-011/-021 FWD TUBE INTO D3391-013/-023 MID TUBE USING SECTION 32.7 OF ICA-D412-742 AS A GUIDELINE EXCEPT INSTALL D3591-1 BUSHINGS AS SHOWN IN DETAIL A USING LPS LABORATORIES LPS-3 CORROSION INHIBITOR PRIOR TO INSTALLING THE D2571/D2572 SADDLES.

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9364-011	BUSHING INSTALLATION
2	D3591-1	BUSHING

REFERENCE ONLY



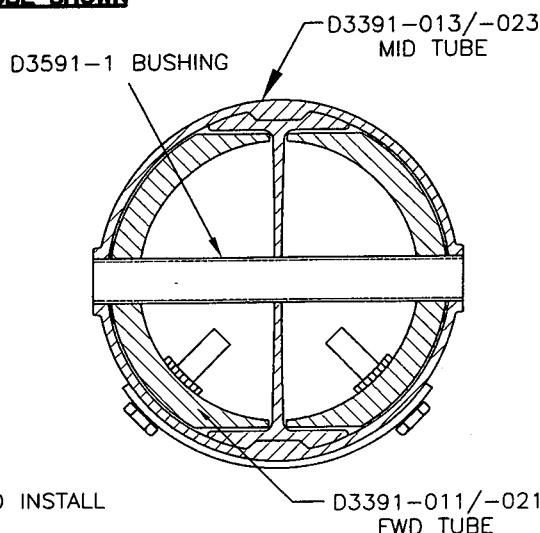
D412-742-011/-013 SKIDTUBE SHOWN



ENSURE BOLT IS FASTENED PRIOR TO TRANSFER DRILLING (REF)

OPEN TO $\varnothing 0.500 \pm_{0.000}^{0.006}$ AND INSTALL D3591-1 BUSHING (2 PLACES)

DETAIL A: D3591-1 BUSHING INSTALLATION LOCATION



SECTION B-B

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QA: N/C Closed: _____ Date: _____

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